

Monday, 27/04/2009 11:42:22 AM
Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PEDAL ARM
Job Number	: 47492		
Estimate Number	: 10868		
P.O. Number	:	Part Number	: D32061 GY
This Issue	: 27/04/2009 S.O. No. :	Drawing Number	: D3206 REV A
Print Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: A
Previous Run	: 43619	Material	:
Written By	:	Due Date	: 10/05/2009 Qty: 6 Um: Each
Checked & Approved By	: <u>27040427</u>		
Comment	: Est. A 04.04.15 New issue KJ/RF Est Rev:B Now On Waterjet 06-12-13 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NS125	4130 Sheet .125 (11GA)
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Comment: Qty.: 0.1848 sf(s)/Unit Total : 1.1088 sf(s)

4130 Sheet .125 (11GA)

Batch: 103505 IB 9-5-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3206

Dwg Rev: A

Prog Rev: A

IB 9-5-6

(8)

2-Deburr if necessary

IB 9-5-6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 9-5-6

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

50165/06 (x8)

5.0	POWDER COATING	POWDER COATING
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M109091

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:30

OVEN TEMPERATURE:

320°

FL 09/05/11

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 11:42:22 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ARM

Job Number: 47492

Part Number: D32061

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME:

9:00

FD 09/05/11 (8)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(8)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 09-05-11

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57147

09/05/11 (8)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/12 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-05-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47492
Description: PEDAL ARM		Part Number: D3206-1
Inspection Dwg: D3206-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .191	+ .005 - .001	.192	*			
Ø .257	+ .006 - .001	.258	*			
1.000	± .010	.999	*			
1.400	± .010	1.402	*			
.210	± .010	.212	*			
.610	± .010	.616	*			
3.350	± .010	3.350	*			
.800	± .010	.802	*			
5.350	± .010	5.349	*			
.300	± .010	.302	*			
.347	± .010	.351	*			
2.900	± .010	2.902	*			
1.400	± .010	1.406	*			
.400	± .010	.397	*			
.600	± .010	.602	*			
.125	± .010	.125	*			

Measured by: IB	Audited by: S	Prototype Approval: A
Date: 9-5-6	Date: 09/05/06	Date: A

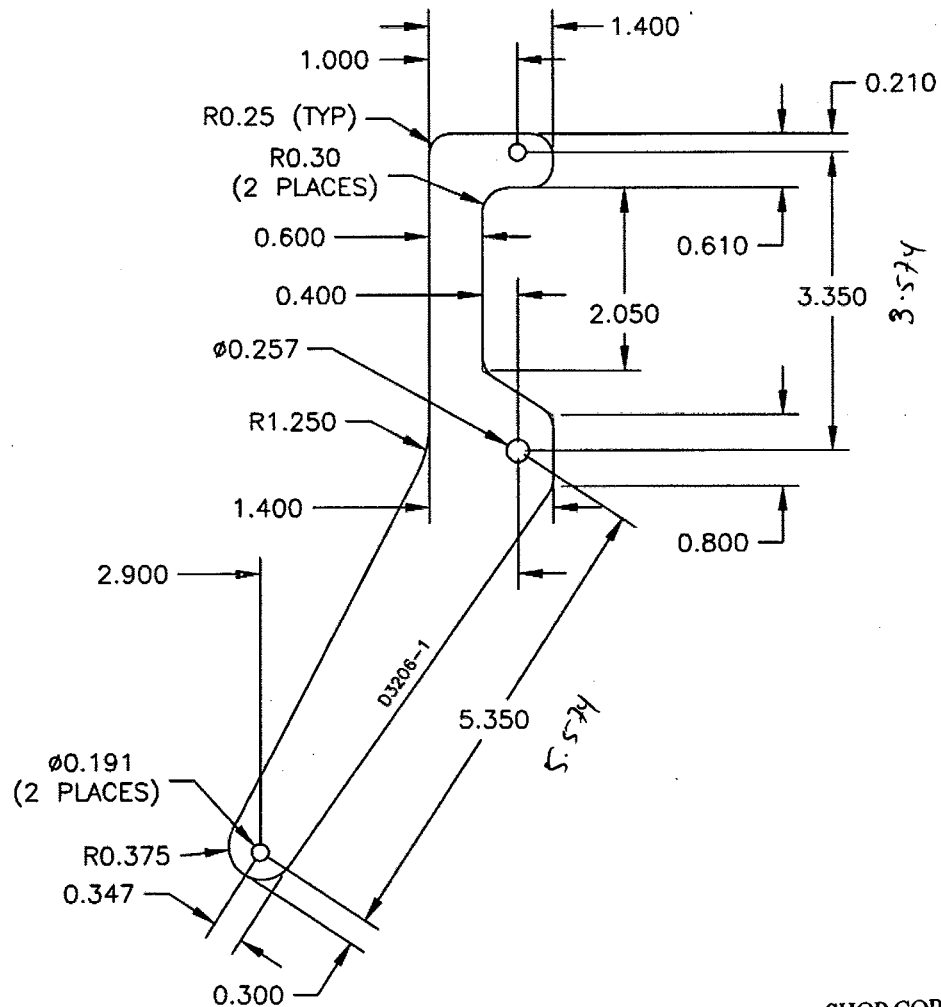
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Handwritten signature]



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3206	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE PEDAL ARM	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05



NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNERS 0.005 TO 0.010
- 2) MATERIAL: AISI 4130N SHEET, 11 GAUGE (M4130N-S125)
- 3) FINISH POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005.4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47492

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries